

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010557**Date Inspected:** 28-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang, Ye Yong Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

WEST TOWER LIFT #1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049541 performing Flux Cored Arc Welding process for the weld WSD1-A423-B/H-91 located on PCMK West tower lift 1 to the base plate. ZPMC QC Mr. Qiu Wen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 062126 performing Flux Cored Arc Welding process for the weld WSD1-A423-B/H-102 located on PCMK West tower lift 1 to the base plate. ZPMC QC Mr. Qiu Wen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

OBG SEGMENT 4 WEST

WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector observed ZPMC qualified welders 048659 and 049769 performing Shielded Metal Arc Welding process for the weld joint SEG17A-007 located on PCMK weld between side panel (counter weight side) and bottom panel of OBG segment 4 West. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. The CWR identified as CWR-904.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AW- 1BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571 performing Shielded Metal Arc Welding process for the weld OBW1A-008 located on PCMK Bottom panel splice weld between OBG segment 1AW and 1BW. ZPMC QC Mr. Feng Yang Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM- Repair-1.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
